

What is claimed is:

5

1. A folded tube for a heat exchanger comprising:

a base;

10

a top spaced from and opposing the base;

a first side interposed between the base and the top along one side thereof;

15

a second side interposed between the base and the top along another side thereof; and

each of the base and the top having at least one internal half web;

20

wherein the at least one top internal half web abuts the at least one base internal half web to define a plurality of fluid ports and wherein there is at least one tube locking feature.

25

2. A folded tube as set forth in claim 1 wherein the generally planar sheet is shaped such that in forming the tube the width across the tube is larger than the height of the tube.

3. A folded tube as set forth in claim 1 wherein the at least one internal half web has a plurality of serrations to mix the fluid flowing through the fluid ports.

30

4. A method of making a folded tube for a heat exchanger comprising the steps of:

5 providing a generally planar sheet;

folding the sheet and forming at least one top internal half web having a first fold portion and a second fold portion and at least one base internal half web having a first fold portion and a second fold portion;

10

folding the sheet and forming a base and a top opposing the base and a first side interposed between the top and the base and a second side interposed between the top and the base such that the at least one top internal half web abuts the at least one base internal half web to provide a plurality of fluid ports.

15

5. A method as set forth in claim 4 wherein the step of forming a plurality of internal half webs further comprises the step of providing a tube locking feature.

6. A method of making a folded tube as set forth in claim 5 wherein the generally 20 planar sheet is shaped such that in forming the tube the width across the tube is larger than the height of the tube.

7. A method as set forth in claim 6 wherein edges of the planar sheet formed are flat edges and the tube locking feature is located on the end of the tube.

25

8. A method as set forth in claim 7 wherein the flat edges being formed close on the height side and have end edges being doubled back against the wall to at least one material thickness in length.

9. A folded tube as set forth in claim 1 wherein the at least one tube locking feature is supported with a 'T' shaped wall.
10. A folded tube as set forth in claim 1 wherein the at least one tube locking feature is contained within a 'U' shaped interior wall.  
5
11. A folded tube as set forth in claim 10 wherein the 'U' shaped interior wall is doubled.
- 10 12. A folded tube as set forth in claim 7 wherein the tube has folded end edges forming perpendicular walls.
13. A folded tube as set forth in claim 11, wherein the tube has folded end edges forming perpendicular walls.  
15
14. A folded tube for a heat exchanger comprising:
  - a base;
  - a top spaced from and opposing the base;
  - a first side interposed between the base and the top along one side thereof;
  - 20 a second side interposed between the base and the top along another side thereof; and
  - each of the base and the top having at least one internal oriented portion;
- 25 wherein the at least one top internal oriented portion abuts the at least one base internal oriented portion to define a plurality of fluid ports and

wherein there is least one tube locking feature.

15. A folded tube as set forth in claim 14, wherein at least one tube locking feature is at the tube end or other than the tube end.